

Customer	: CU-DAR001*Dart Helicopters Services	Drawing Name	: SEAT FRAME ASSEMBLY
Job Number	: 33363		
Estimate Number	: 11122		
P.O. Number	: N/A	Part Number	: D3016041
This Issue	: 7/9/2007	S.O. No.	: N/A
Prsht Rev.	: NC	-Drawing Number	: D3016 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25960	Drawing Revision	: A
		Material	: N/A
		Due Date	: 7/30/2007
Written By	: <u>[Signature]</u>	Qty:	1
Checked & Approved By	: <u>[Signature]</u>	Um:	Each
Comment	: Est. A 01.09.19 New issue EC		

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10 M4130NT0750W049 4130 Tube .750 OD x.049W



Comment: Qty.: 6.8250 f(s)/Unit Total: 6.8250 f(s)  
4130 Tube .750 OD x.049W  
Cut- AISI 4130N tube, Ø3/4" x 0.049" wall  
Batch: M100843

11/07/08/22

20 M4130NT1000W049 4130 Tube 1.0"D X .049"W



Comment: Qty.: 2.6250 f(s)/Unit Total: 2.6250 f(s)  
4130 Tube 1.0"D X .049"W M1159

M1159/

1507/08/22

3.0	M4130NT0500W049	4130 Tube .500 OD x.049W
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Comment: Qty.: 4.2000 f(s)/Unit Total : 4.2000 f(s)  
4130 Tube .500 OD x.049W  
Cut- AISI 4130N tube, Ø1/2" x 0.049" wall  
Batch: M 17109

11/07/08/22

40	D301617	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit      Total : 1.0000 Each(s)

Gusset

Pick:

Qty	Part Number	Description	Batch
1	D3016-17	Gusset	B22066

Batch  
B22066

07/08/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 7/9/2007 11:47:12 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 33363

Part Number: D3016041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D301613

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Bracket

Pick:

Qty Part Number Description Batch

2 X D3016-13 Bracket B16404

07/08/22

6.0

D301615

Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Gusset

Pick:

Qty Part Number Description Batch

1 D3016-15 Gusset B25762

07/08/22

7.0

D30201

Fitting



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Fitting

Pick:

Qty Part Number Description Batch

2 D3020-1 Fitting B22690

07/08/22

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-08-23

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Weld as per Dwg D3016

A/R Steel Rod Batch: M15684

4-Transfer Drill Holes to D3016-041 From D3021-041

07/08/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/09/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:47:12 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 33363

Part Number: D3016041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-08-23

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-08-23

12.0

POWDER COATING

POWDER COATING



M10484



(1X)

Comment: POWDER COATING

Install paint screws on fitting ends

Powder Coat Grey sandtex (Ref. 4.3.5.6) as per QSI 005

M-k 07/08/27

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 07/08/28

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

M 07/08/28

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1)  
D 08/09/12

Job Completion



U 07-09-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

#### NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

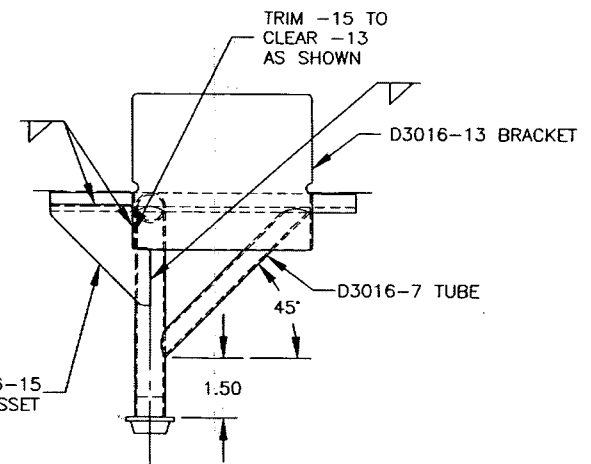
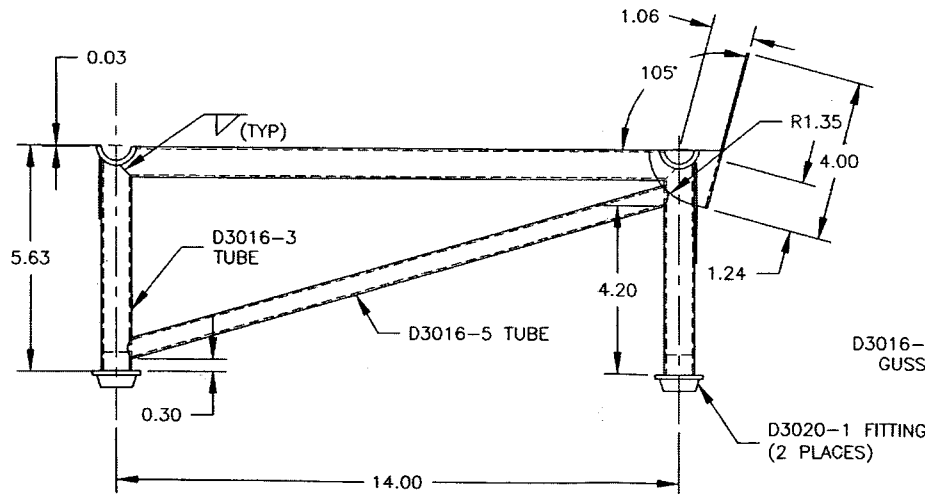
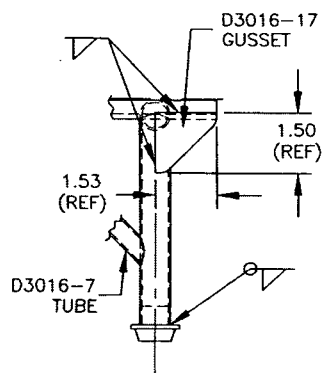
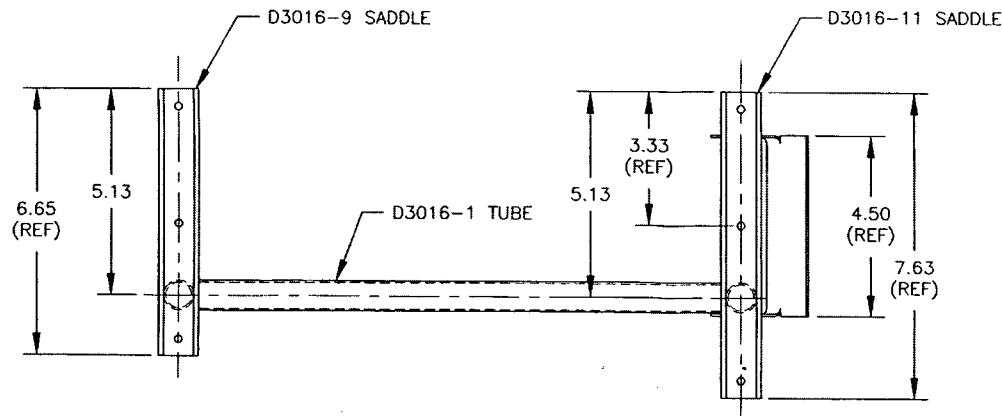
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01.05.30 *#*

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# D3016-041 SEAT FRAME ASSEMBLY



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01.05.30

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DRAWN BY

**DART**

DART AEROSPACE LTD.  
HARRISBURG, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.

D3016

REV. A

SHEET 2 OF 3

DATE

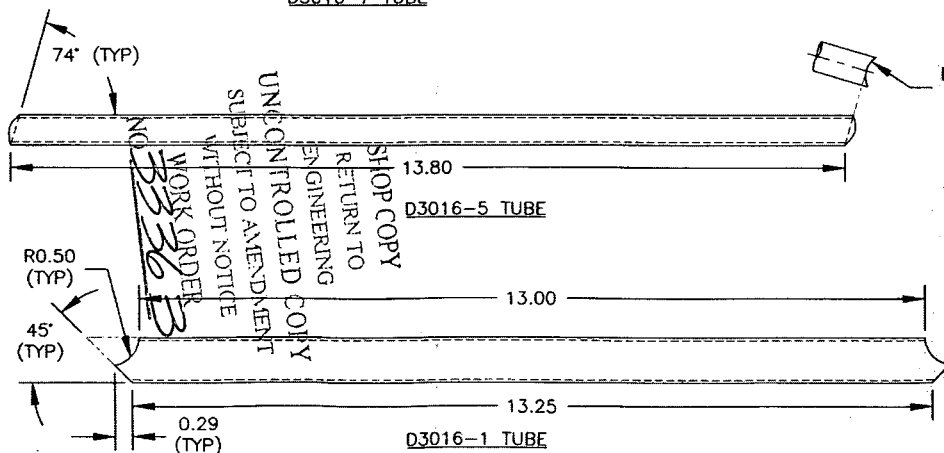
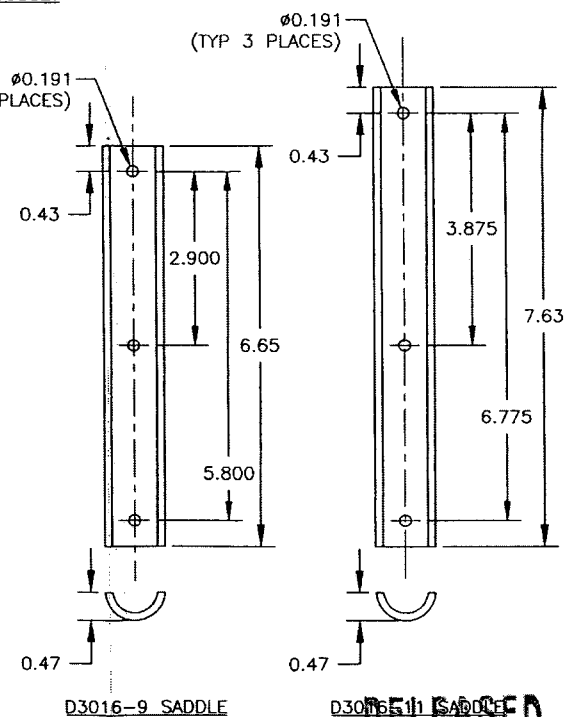
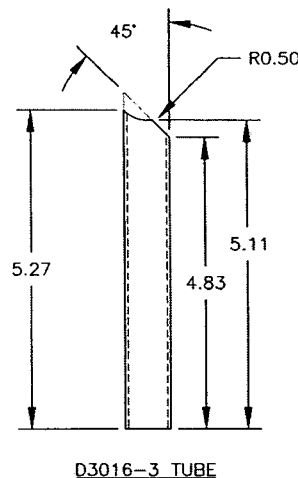
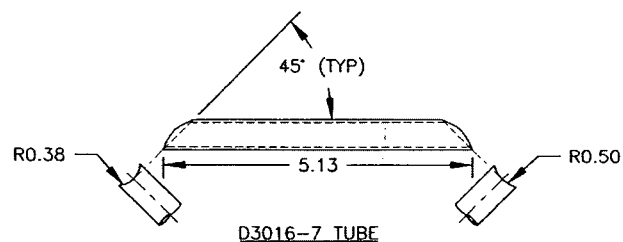
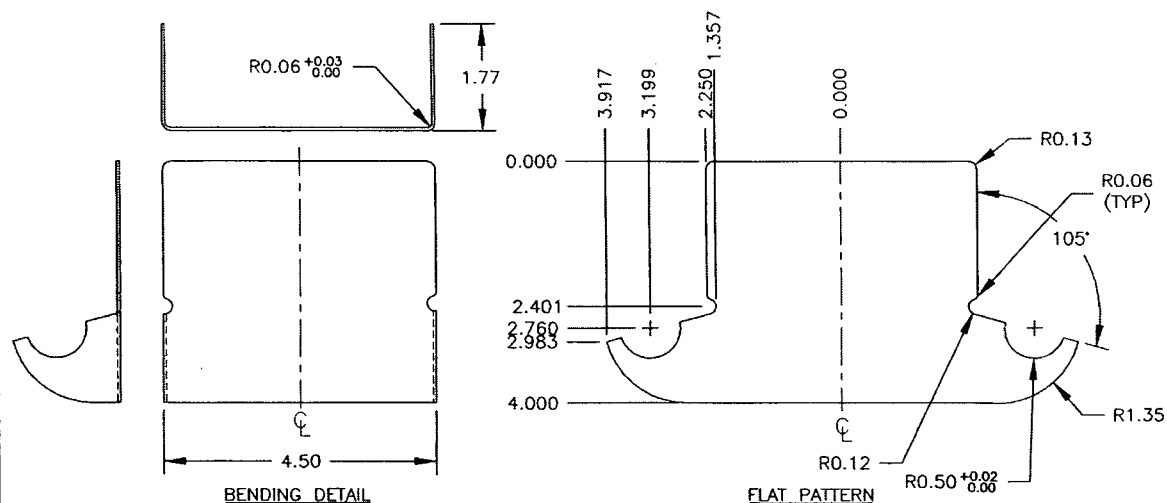
01.05.18

TITLE

SEAT FRAME ASSEMBLY

SCALE

1:3



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CHECKED	APPROVED	DRAWING NO. D3016	REV. A SHEET 3 OF 3
DATE 01.05.18	TITLE SEAT FRAME ASSEMBLY	SCALE	1:2

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9.05.30